



Cortén Mag

AWS A5.28: ER80S-G EN ISO 14341-A- G 50 4 C1/M21 Z3Ni1
EN ISO 636-A- W Z3Ni1

DESCRIPTION

Excellent resistance to atmospheric agents thanks to the presence of Cu, Cr, Ni. Suitable for bridges, cranes, ground moving machines, boilers, building structures, petrochemical sector, fans, gas pipes, fume suction, etc.

WELDING POSITIONS



CURRENT

DC+

GAS

Ar/ Co2 (M21, M20)

BASE MATERIALS

Construction steel, cortén steel

S235JRW, S235J2G3 ; Patinax 37, Alcodur50, Koralpin 52, ; S355J2G3Cu, 9CrNiCuP3-2-4 ;
Corten A - B1 ; Itacor ; WTst52.3, S355K2W

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_{p 0,2}</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
590	490	24	> 60 J (-30° C)

WELD METAL COMPOSITION(%)

C	Si	Mn	P	S	Cu	Cr	Ni	Mo	Al	V	Ti+Zr	
0,08	0,8	1,40	<0,01	<0,01	0,35	0,3	0,8	<0,05	<0,02	<0,03	<0,15	

PACKAGING & WELDING PARAMETERS

Dimension(mm)	0,8	1,0	1,2	1,6
Spool size(kg)	16	16	16	16
Wire feeding (m/min)	2,0-10,8	2,7-15	2,7-12,4	3,1-12
Ampere (A)	90-160	150-250	220-320	250-400
Volt (V)	18-22	22-28	26-32	28-36

EQUIVALENT FILLER METALS

TIG	Meltolit Cortén
MMA	Meltolit Cortén E
FCW/MCW	Megafil 781R, Megafil 281M